

**Work Order ID 51740**

Page 1

September 1, 2009 8:38:30 AM

Item ID: D2989-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Basket Lid Assembly

Start Date: 9/07/09 Start Qty: 1.00



Cust Item ID:

Required Date: 9/18/09 Req'd Qty: 1.00



Customer:

**Reference:**

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D2989

Rev D

100



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989

2- tack weld mesh on basket as per dwg D2989 using DT9445 jig  
\*\*\*\*cut cutouts with zip cut as per dwg D3832\*\*\*\*3- remove from jig and weld lable plate as per dwg D2989  
A/R ER316 S.S. Rod Batch: *M109213**8/10/09/08*

110



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Quality Control

Memo

*PL 09.09.09*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

→ S 09/07/09

0.00



QC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 9/07/09 Start Qty: 1.00



Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan:

Date: Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

✓ Memo

0.00

Draw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp✓ Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg  
D2989

3-Wing walk D2989-041 as per Dwg D2989 and QSI 005 4.4

Spray Paint Black:  Wing Walk: 

1ST COAT: M112260

START TIME: 8:45AM

OVEN TEMPERATURE: 400°F

FINISH TIME: 9:15AM

\*\*\*\*\* 2nd coat if necessary \*\*\*\*\*

2ND COAT:

START TIME: 9:30AM

OVEN TEMPERATURE: 400°F

FINISH TIME: 10:00AM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

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Required Date: 9/18/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

131



HandFinish

Hand Finishing

Operation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Wing Walk as per dwg QSI005 4.4 Batch M112106 0.00

Spray Paint M111283

HJ 09/09/0

(X)

S

Memo

0.00

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

PK 09-09-11

①.

Memo

0.00

141



Packaging

Packaging

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

BL 09-09-14

①.

Memo

0.00

**Work Order ID 51740**

Page 5

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Customer:

**Reference:**

Approvals: Process Plan:

Date: Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

**Sequence ID/  
Work Center ID****Operation  
Description****Set Up/  
Run Hours****Draw  
Number****Draw  
Rev.****Plan  
Code****Accept  
Qty****Reject  
Qty****Reject  
Number****Insp.  
Stamp**

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/09/15

09-9-14

# Picklist Print

September 1, 2009 8:38:29 AM

Page 1

6

Work Order ID: 51740



Parent Item: D2989-041RevD



Parent Item Name: Basket Lid Assembly

Start Date: 9/07/09

Required Date: 9/18/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2221-1RevH		Manufactured	No			100	Each	13.0000	2.0000			

Rib

## Warehouse

### Location

Main Warehouse

ST

Loc Qty

1

Loc Code

48101

\_\_\_\_\_

Main Warehouse

WA

12

51250

12

D2506RevF

Manufactured No



Label Plate

100 Each 4.0000 1.0000



2x 88 09/09/03

## Warehouse

### Location

Main Warehouse

ST

Loc Qty

4

Loc Code

44275

\_\_\_\_\_

51135

1

3

\_\_\_\_\_

1x 84 09/09/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

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Work Order ID: 51740



Parent Item: D2989-041RevD



Parent Item Name: Basket Lid Assembly

Start Date: 9/07/09

Required Date: 9/18/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2512-7RevE		Manufactured	No			100	Each	7.0000	1.0000			



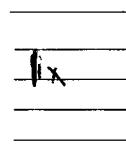
Rib

## Warehouse

### Location

#### Main Warehouse

ST	7
43987	1
44865	1
48326	1
48666	4



SM 09/09/03

D2581RevA1



Mounting Bracket

Manufactured No

100

Each

39.0000 2.0000



## Warehouse

### Location

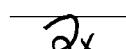
#### Main Warehouse

ST	13
46086	2
48428	1
51120	10



#### Main Warehouse

WA	26
50872	26



W/O:

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

September 1, 2009 8:38:29 AM

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Parent Item: D2989-041RevD



Parent Item Name: Basket Lid Assembly

Start Date: 9/07/09

Required Date: 9/18/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2989-13RevD		Manufactured	No			100	Each	6.0000	2.0000			

Rib

## Warehouse

### Location

#### Main Warehouse

ST 6

48452 2

50579 4

ax 8/10/09/03

D2989-19RevD

Manufactured No

100 Each

11.0000 2.0000

Rib

## Warehouse

### Location

#### Main Warehouse

ST 7

44867 1

47976 2

48102 2

50823 2

ax 8/10/09/03

#### Main Warehouse

WA 4

51338 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

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Page 4

September 1, 2009 8:38:29 AM

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Parent Item: D2989-041RevD



Parent Item Name: Basket Lid Assembly

Start Date: 9/07/09

Required Date: 9/18/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3832-3RevA		Manufactured	No			100	Each	4.0000	1.0000			

Mesh (Lid)

## Warehouse

### Location

Main Warehouse

ST	4
47747	1
48608	3

D3833-3RevA

Manufactured

No 100 Each 9.0000 2.0000



Mesh (Lid End)

## Warehouse

### Location

Main Warehouse

ST	9
46308	9

1x 8/09/03

2x 8/09/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

# Picklist Print

Page 5

September 1, 2009 8:38:29 AM

Work Order ID: 51740



Parent Item: D2989-041RevD



Parent Item Name: Basket Lid Assembly

Start Date: 9/07/09

Required Date: 9/18/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3836-041RevA		Manufactured	No			100	Each	5.0000	1.0000			

Rib Assembly (Basket Lid, LH)

## Warehouse

### Location

#### Main Warehouse

ST 3

48440 1

51336 2

#### Main Warehouse

WA 2

50578 2

D3836-042RevA

Manufactured

No

100

Each

5.0000 1.0000

Rib Assembly (Basket Lid, RH)

## Warehouse

### Location

#### Main Warehouse

ST 3

48441 1

51337 2

#### Main Warehouse

WA 2

50577 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Page 6

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Parent Item: D2989-041RevD



Parent Item Name: Basket Lid Assembly

Start Date: 9/07/09

Required Date: 9/18/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3852-041RevA		Manufactured		No		100	Each	5.0000	1.0000			

Rib Assembly

## Warehouse

### Location

#### Main Warehouse

ST	5
48098	2
50580	1
51333	2

### Loc Qty

### Loc Code

1x

SM 09/09/03

D3852-042RevA

Manufactured No

100 Each 5.0000 1.0000

Rib Assembly

## Warehouse

### Location

#### Main Warehouse

ST	5
48097	2
50581	1
51332	2

1x

SM 09/09/03

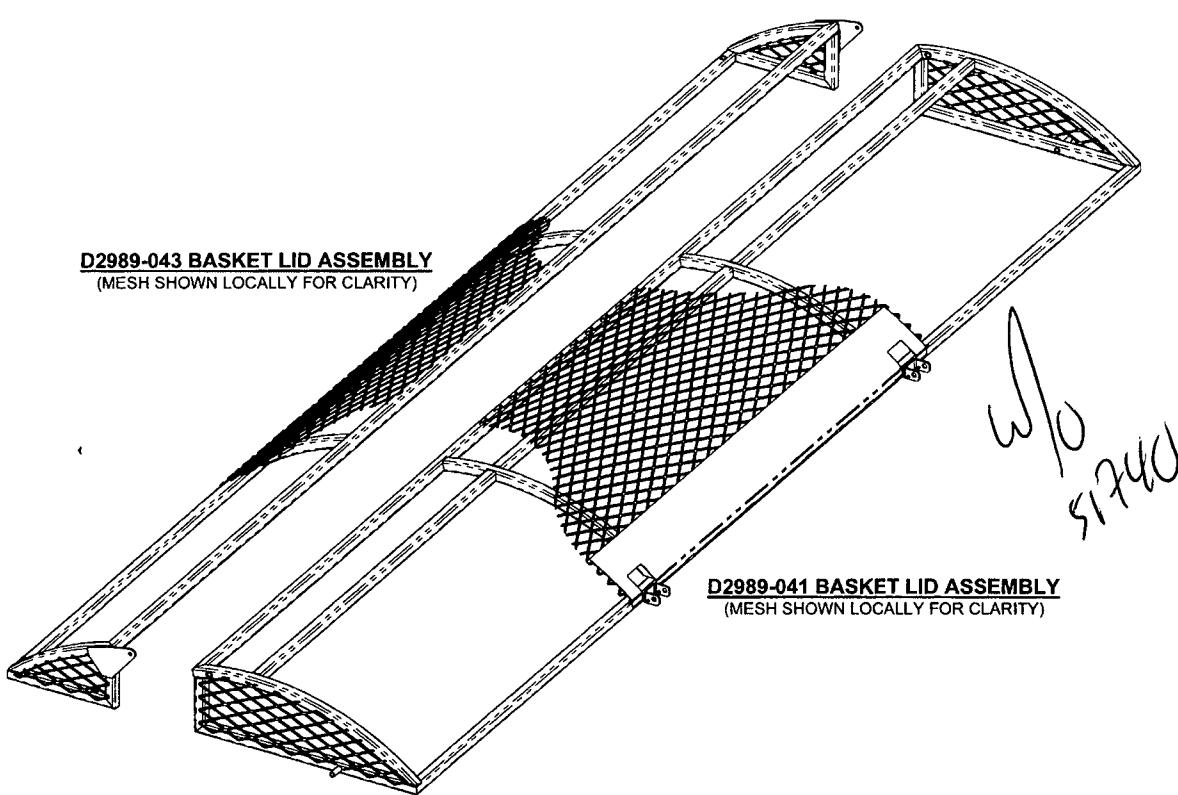
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

8	7	6	5	4	3	2	1
D					D		D
C							C
B							B
A							A
				<p><b>D2989-043 BASKET LID ASSEMBLY</b> (MESH SHOWN LOCALLY FOR CLARITY)</p> <p><b>D2989-041 BASKET LID ASSEMBLY</b> (MESH SHOWN LOCALLY FOR CLARITY)</p> <p>Weld 51740</p>			
<p><b>NOTES:</b></p> <ol style="list-style-type: none"> <li>1) MATERIAL: N/A</li> <li>2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4 SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID</li> <li>3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED</li> <li>4) UNITS: INCHES UNLESS OTHERWISE NOTED</li> <li>5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX</li> <li>6) IDENTIFICATION: N/A</li> <li>7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs</li> <li>8) WELD PER DART QSI 004</li> </ol>				<p><b>RELEASED</b> 08/11/18 MJD</p>			
<p>1) MATERIAL: N/A</p> <p>2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4 SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID</p> <p>3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED</p> <p>4) UNITS: INCHES UNLESS OTHERWISE NOTED</p> <p>5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX</p> <p>6) IDENTIFICATION: N/A</p> <p>7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs</p> <p>8) WELD PER DART QSI 004</p>				<p><b>REVISIONS:</b></p> <p>D REVISED -041/043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (2N D3-1); D3836-041 REPLACES D2989-9/15; D3836-042 REPLACES D2989-10/15; D3838-041 REPLACES D2989-1/7; D3838-042 REPLACES D2989-2/7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2/7; D2989-4 REMOVED D327-1 (NOW INSTALLED ON D3836 DWG); D2989-9/10 (NOW ON D3836 DWG), D2989-1/11-15 (NOW ON D3838 DWG) AND D2989-11/12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM</p> <p>C FRAME MATERIAL WAS 0.050 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD</p> <p>B ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS</p> <p>A NEW ISSUE</p>			
<p>REV.</p>				<p>DESCRIPTION</p>			
<p>DESIGN</p>				<p>DS</p> <p><b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA</p>			
<p>DRAWN</p>				<p>REV. D</p>			
<p>CHECKED</p>				<p>DRAWING NO.</p>			
<p>MFG. APPR.</p>				<p>D2989</p>			
<p>APPROVED</p>				<p>REV. D</p>			
<p>DE APPR.</p>				<p>SHEET 1 OF 5</p>			
<p>DATE</p>				<p>TITLE</p>			
<p>08.09.24</p>				<p>SCALE</p>			
<p></p>				<p>NTS</p>			
<p></p>				<p>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</p>			

W/O:

## WORK ORDER CHANGES

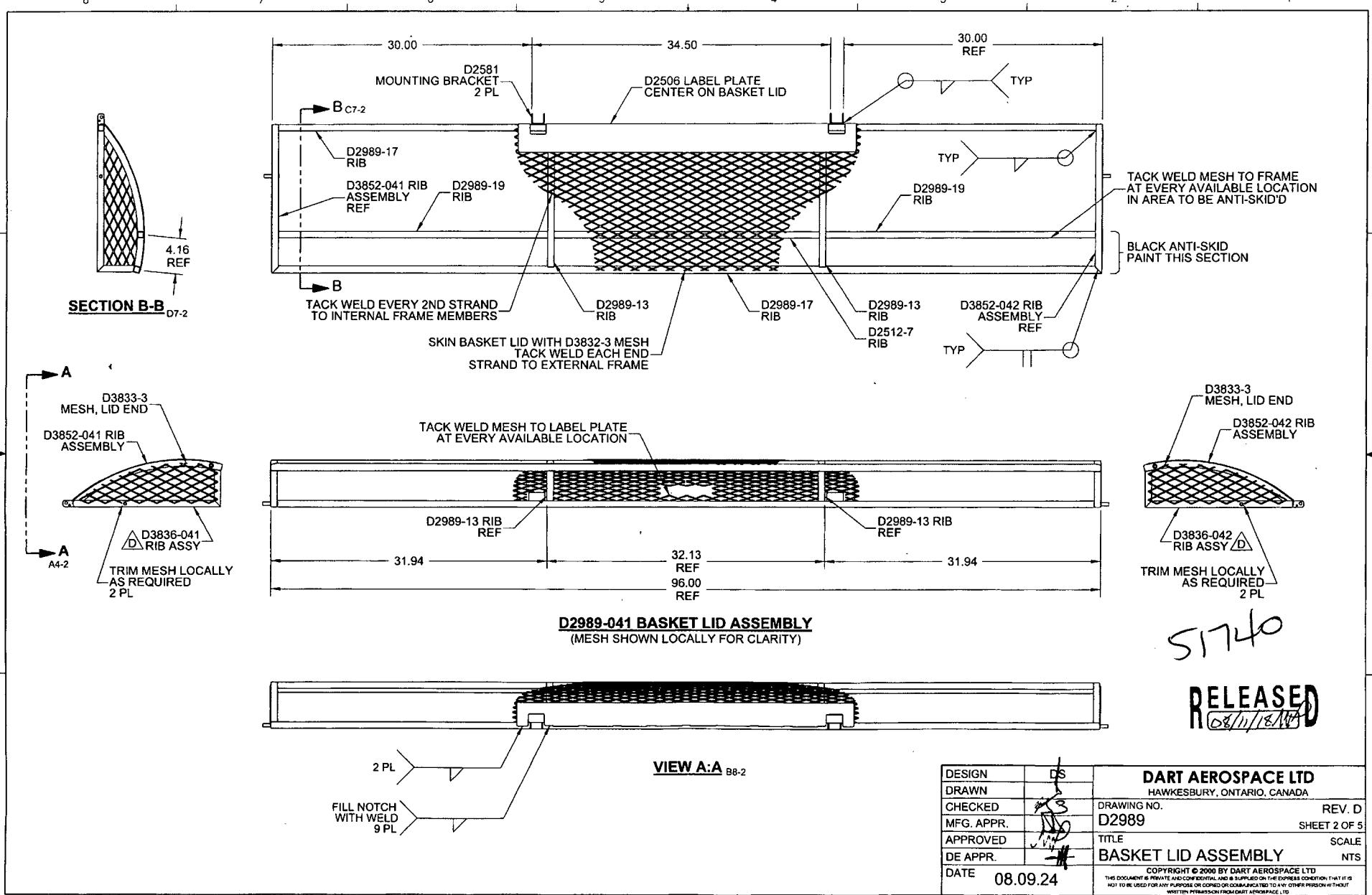
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date &amp; initial all entries



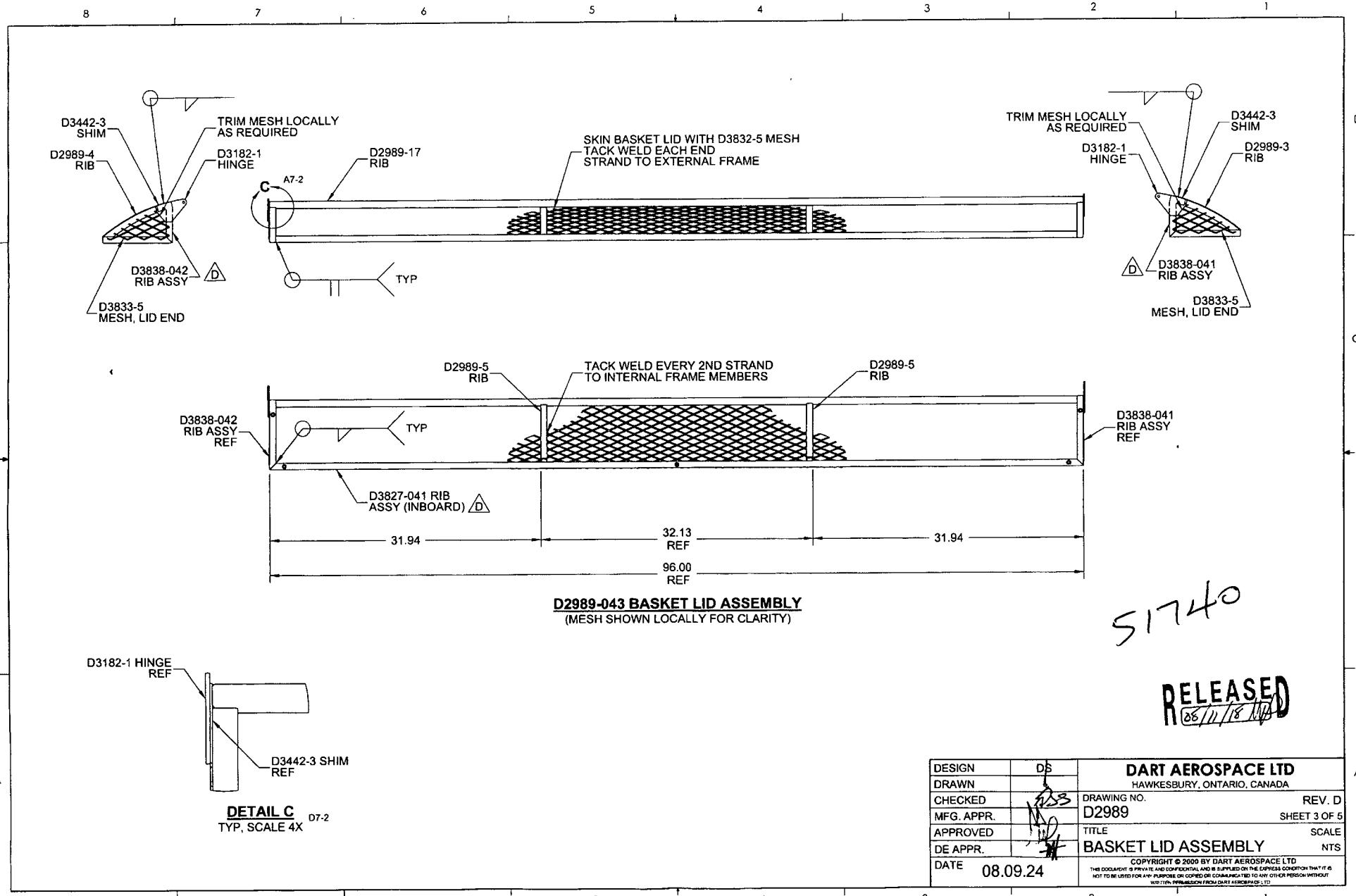
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NOTE: Date & initial all entries



51740

RELEASED  
08/11/18 MHD

DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	2/23	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>BASKET LID ASSEMBLY</b>	
DATE	08.09.24	NTS	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

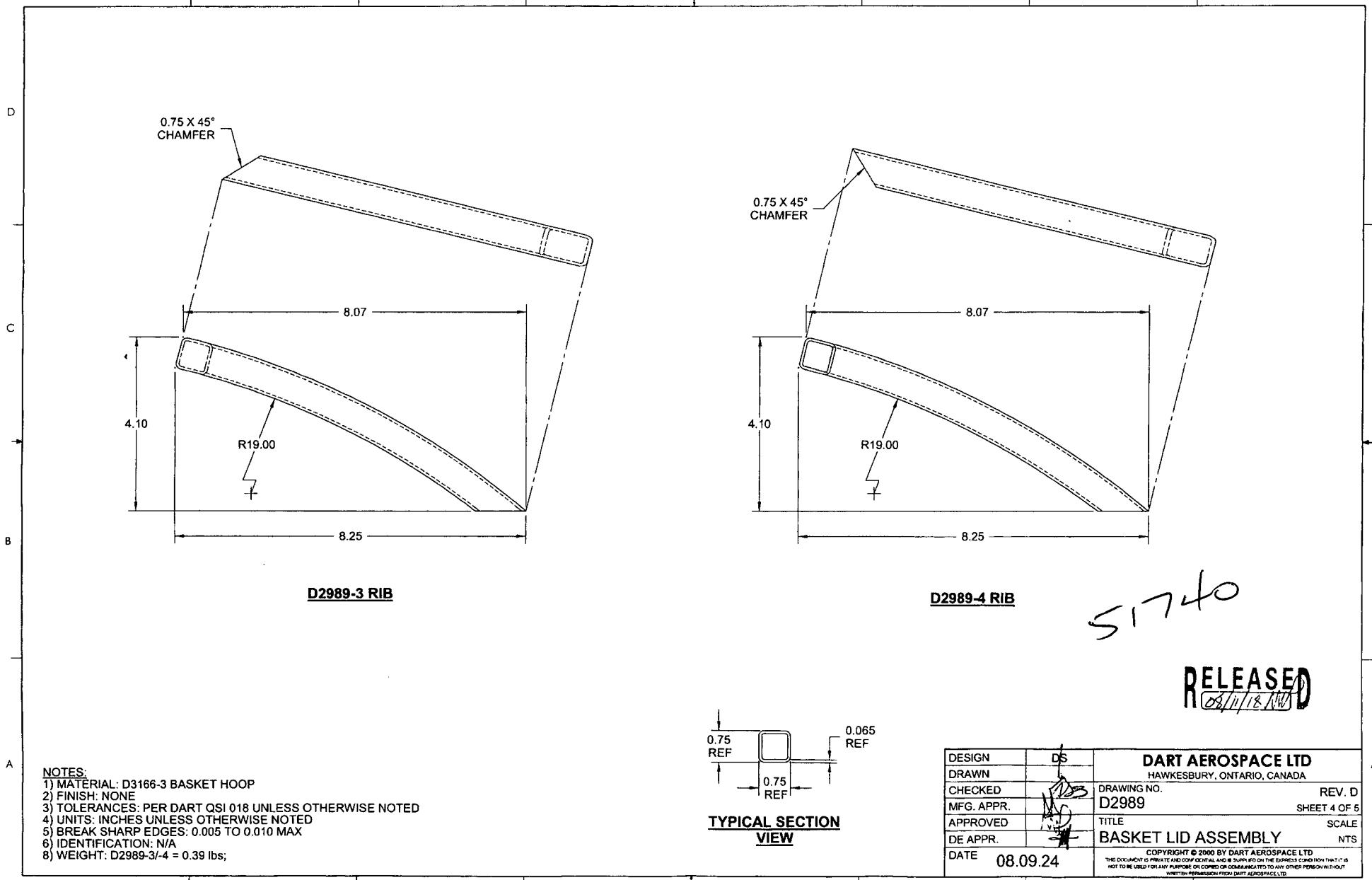
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



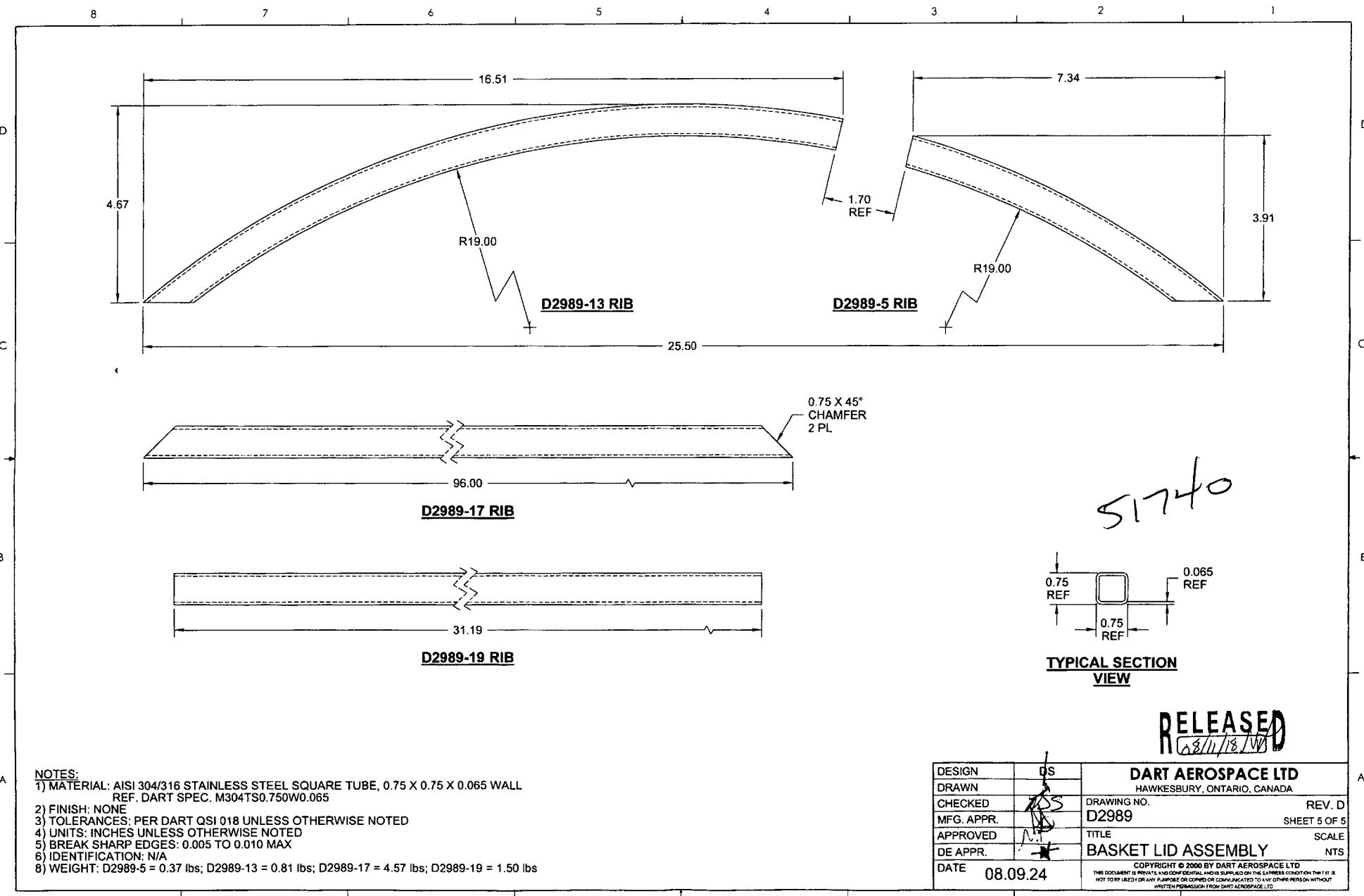
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries